

Date: Monday, 10/16/2006 2:01:58 PM  
 User: Kim Johnston

## Process Sheet

|  |  |
|--|--|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services                                      | <b>Drawing Name</b> : PLUG                                 |
| <b>Job Number</b> : 29018  |  |
| <b>Estimate Number</b> : 12338   |  |
| <b>P.O. Number</b> : N/A   | <b>Part Number</b> : D3492045                              |
| <b>This Issue</b> : 10/16/2006 <b>S.O. No.</b> : N/A                                       | <b>Drawing Number</b> : D3492 REV B                        |
| <b>Prsht Rev.</b> : NC   | <b>Project Number</b> : N/A                                |
| <b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS                                      | <b>Drawing Revision</b> : B                                |
| <b>Previous Run</b> : 28276  | <b>Material</b> : N/A                                      |
| <b>Written By</b> : _____  | <b>Due Date</b> : 11/5/2006 <b>Qty:</b> 40 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> : <u>JA 06/10/16</u>                                      |  |
| <b>Comment</b> : Est Rev: A 06.03.21 New Issue JLM<br>Est Rev: B 06-08-28 As per Rev B JLM |  |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |              |                         |
|-----|--------------|-------------------------|
| 1.0 | M6061T6R0500 | 6061-T6 Round Bar .500" |
|-----|--------------|-------------------------|

**Comment:** Qty.: 0.0656 f(s)/Unit Total: 2.6250 f(s)

6061-T6 Round Bar .500"

(M6061T6R500)

Batch: M101421

M19296 16"

16"



06/10/17

|     |          |                          |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|

**Comment:** HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA634 &amp; Dwg D3492

Dwg Rev: B

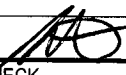
Folio Rev: A



06/10/17

45

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

06/10/18

45

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|

**Comment:** SECOND CHECK

J.F.

06/10/18

45

|     |             |                               |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

45

ml 06/10/20

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/01/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Monday, 10/16/2006 2:01:59 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 29018

Part Number: D3492045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*JK 06/10/23 x 44*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  
(Flat End Only)

*9.11 06/10/24 (44)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FC 06 10 25 (44)*

9.0

NAS1611003

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-003 O-RING

~~10 X 101124~~ M102170

*FC 07 01 11 (44) (P10)*

~~10 X 101699~~

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube  
A/R 55-O'Ring Lube Batch: 101223

*FC 07-01-11 (44)*

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*IM 07 01 11*

*(44)*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

*FP15 IM 07 01 11*

*(44)*

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/01/11*

*IM 07.01.11*

**Dart Aerospace Ltd**

| W/O:     |      | WORK ORDER CHANGES  |              |          |     |                                     |                                |
|----------|------|---|--------------|----------|-----|-------------------------------------|--------------------------------|
| DATE     | STEP | PROCEDURE CHANGE  | By           | Date     | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector       |
| 07-01-11 | 9.0  | NAS1611-005 is needed for the plug. Make permanent change. <i>[Signature]</i> | U Est. Chg'd | 07-01-11 |     | <i>[Signature]</i><br>07-01-11      | <i>[Signature]</i><br>07-01-11 |
|          |      |   |              |          |     |                                     |                                |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

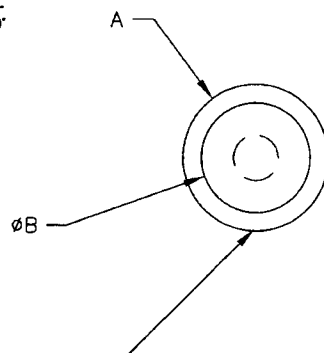
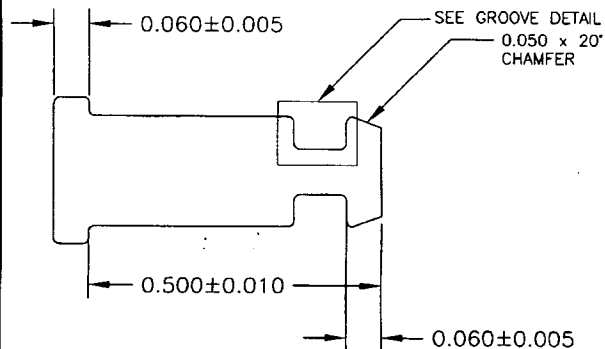
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

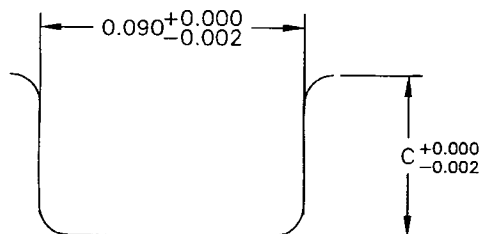
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries





D3492-1/-3/-5/-7 PLUGS IN ACCORDANCE WITH TABLE 1



GROOVE DETAIL

TABLE 1 D3492-1/-3/-5/-7 PLUG DIMENSIONS

| P/N     | A     | B     | C     | MATERIAL SPEC |
|---------|-------|-------|-------|---------------|
| D3492-1 | 0.625 | 0.394 | 0.055 | M6061T6R0.625 |
| D3492-3 | 0.750 | 0.582 | 0.045 | M6061T6R0.750 |
| D3492-5 | 0.375 | 0.188 | 0.045 | M6061T6R0.375 |
| D3492-7 | 0.500 | 0.270 | 0.045 | M6061T6R0.500 |

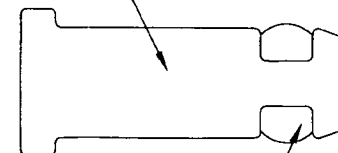


**D3492-1/-3/-5/-7 PLUG NOTES**

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6RD.DDD)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTE
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

NO. 29018  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

D3492-1/-3/-5/-7 PLUG IN ACCORDANCE WITH TABLE 2



NAS1611-005/-007/-010/-013 O-RING IN ACCORDANCE WITH TABLE 2

**D3492-041/-043/-045 PLUG ASSEMBLY**

RELEASED  
06.10.02.89  
REV. 60N #351

**D3492-041/-043/-045 PLUG ASSEMBLY PARTS LIST**  
(TABLE 2)

| Qty -041 | Qty -043 | Qty -045 | Qty -047 | Part Number | Description   |
|----------|----------|----------|----------|-------------|---------------|
| X        |          |          |          | D3492-041   | PLUG ASSEMBLY |
|          | X        |          |          | D3492-043   | PLUG ASSEMBLY |
|          |          | X        |          | D3492-045   | PLUG ASSEMBLY |
|          |          |          | X        | D3492-047   | PLUG ASSEMBLY |
| 1        |          |          |          | D3492-1     | PLUG          |
|          | 1        |          |          | D3492-3     | PLUG          |
|          |          | 1        |          | D3492-5     | PLUG          |
|          |          |          | 1        | D3492-7     | PLUG          |
|          |          | 1        |          | NAS1611-005 | O-RING        |
|          |          |          | 1        | NAS1611-007 | O-RING        |
| 1        |          |          |          | NAS1611-010 | O-RING        |
|          | 1        |          |          | NAS1611-013 | O-RING        |



|          |          |                              |
|----------|----------|------------------------------|
| B        | 06.05.11 | ADD -047; UPDATE DIM A, -045 |
| A        | 06.01.04 | NEW ISSUE                    |
| DESIGN   | DRAWN BY |                              |
| CHECKED  | APPROVED |                              |
| DATE     | TITLE    |                              |
| 06.05.11 | PLUG     |                              |

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**DART AEROSPACE USA, INC.**  
PORT HADLOCK, MA

DRAWING NO. D3492  
SHEET 1 OF 1  
SCALE NTS